



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB877212-08-27
Job Sheet 192393



Part No: RB877212-08-27

Job Qty: 2 pcs *6 mks*

Part Name: Bolt, 1/2-20 UNF x 3-1/4



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/22/19

Job Tracking No:

Due Date: 5/3/19 *May 10*

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB877212-08 Rev D IPP Rev. A 19.02.21 New issue DP Verify DD/IPP Rev. B 19.03.20 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154 - 1	2 pcs	5/3/19	5/3/19	0.00	2.00	SL-154 - 1		<i>JB 19-04-30</i>
110	QC 2	2 pcs	5/3/19	5/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		<i>JB 19-04-30</i>
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S176734

Part: RB877212-08-27

Job No: 192393

Serial No/Batch: S176734

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 04/20/19

DAS
62
9-89

DAS
62
9-89

120	QC 8	2 pcs	5/3/19	0.00 0.00	QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	De 19-04-30
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
130	Outsource - 12 - Black Oxide	2 pcs	5/3/19		GRO002-VC	MA 2019-05-02
140	Packaging 2-1 - Receive - B4B	2 pcs	5/3/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	OP MAY 10 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	

				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
150 QC 6	2 pcs	5/3/19	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	MAY 13 2019 68
				QC 6 - 61	9-89
160 Packaging 3-1 - Stock - B4B	2 pcs	5/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	2 pcs	5/3/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 MAY 13 2019

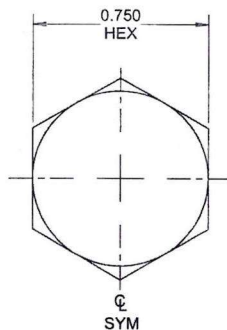
Part Op 100 - 1-Machine as per folio FC 735 FOLIO REV: AA DWG REV: D 2-Deburr
 Descriptions: 130 - -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required

Job BOM

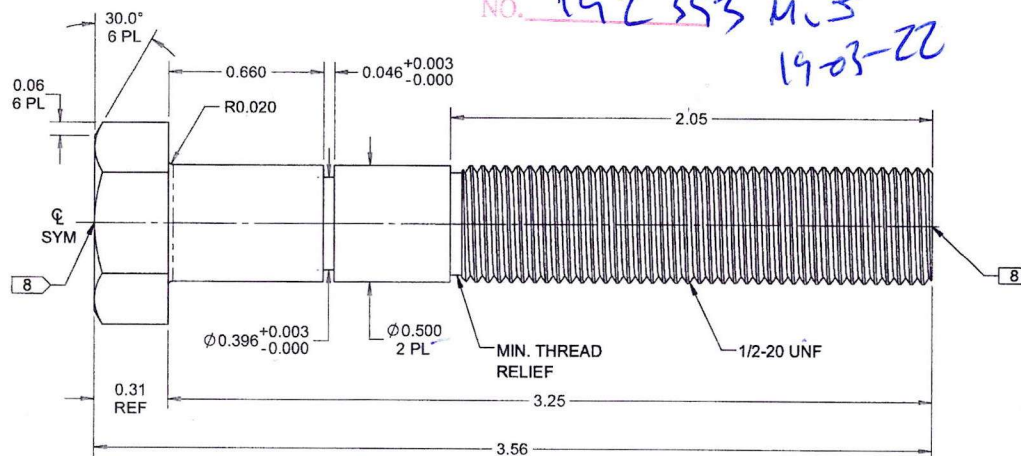
Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.000	AISI 4140 Quenched & Tempered Steel Round Bar 1.000" Dia.	.6260 ft (.313 ea)	100-SL-154 - 1	5093068

Job Allocations

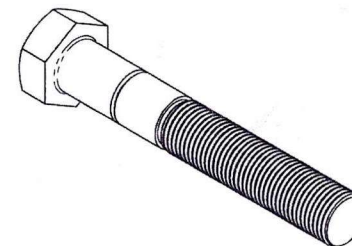
Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	MT-4140QT-R1.000	1	23	0



RB877212-08-27 BOLT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **192353 M.S**
19-03-22



NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 10 OF 11
APPROVED	<i>W</i>	TITLE	SCALE
DATE	3/21/2019	TAIL ROTOR BEARING CUTTER	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043359



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043359

PO Date: 5/2/19

Due Date: 5/10/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186487	RBT400313-1	Adapter Weldment -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed X11	-	5/10/19 MAY 10 2019	11 pcs	0 pcs	11 pcs	\$9.55/pcs	\$105.05
2	193407	RBE350A94-3700-A-05	Foot -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed X24	-	5/10/19 MAY 10 2019	24 pcs	0 pcs	24 pcs	\$2.80/pcs	\$67.20
3	192391	RB877212-08-1	Shaft, Ø3/4 x 4 -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed X6	-	5/10/19 MAY 10 2019	6 pcs	0 pcs	6 pcs	\$1.02/pcs	\$6.12



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PURCHASE ORDER

POHB043359



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	192393	RB877212-08-27	Bolt, 1/2-20 UNF x 3-1/4 -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	5/10/19 MAY 10 2019	6 pcs	0 pcs	6 pcs	\$1.02/pcs	\$6.12 DAS 68 9-89
5	192389	RB877212-08-17	R&I Adapter, Ø1-5/8 x 1-1/2 Outside Processing - Black Oxide -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	5/10/19 MAY 10 2019	6 pcs	0 pcs	6 pcs	\$1.60/pcs	\$9.60
6	193363	RBE350A93-3307-00-01	Retractor -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	5/10/19 MAY 10 2019	18 pcs	0 pcs	18 pcs	\$2.55/pcs	\$45.90
Grand Total:										\$239.99	



Dart Aerospace Ltd.
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PURCHASE ORDER

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Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in dark ink, appearing to be "JD" or similar, located to the right of the Order Notes section.

Plex 5/3/19 9:26 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(018930-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

018930- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

RECEIVED
 MAY 10 2019
 DART AEROSPACE LTD.

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
10-May-2019		Jessie Boisvert		POHB043359				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT400313-1 Rev.	RBT400313-1 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	11	11	0	0	0
2	RBE350A94-3700-A-05 Rev.	RBE350A94-3700-A-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	24	24	0	0	0
3	RB877212-08-1 Rev.	RB877212-08-1 01 -BLACK OXIDE ON SST MIL-DTL-13924D CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-C-81309 OR MIL-C-81309 TYPE 3 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0
4	RB877212-08-27 Rev.	RB877212-08-27 01 -BLACK OXIDE ON SST MIL-DTL-13924D CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-C-81309 OR MIL-C-81309 TYPE 3 AND WIPE OFF EXCESS	BLACK-OXIDE CH	6	6	0	0	0
5	RB877212-08-17 Rev.	RB877212-08-17 R&I ADAPTER 01 - BLACK OXIDE ON SST MIL-DTL-13924D OUTSIDE PROCESSING - BLACK OXIDE BLACK OXIDE FINISH MIL-C-13924 CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
6	RBE350A93-3307-00-01 Rev.	RBE350A93-3307-00-01 01 -OXIDE BLACK [OXIDE BLACK] MIL-C13964 CLASS 1, MIL-C-16173 GRADE 4	OXIDE-BLACK CH	18	18	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.